

Work Order ID 50842

July 31, 2009 8:34:19 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 08/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/04/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-05-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

)

1

110-8-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

①

2E 09/08/10

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 08/08/10

①

φ

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R ☐ ☐ Aluminum Rod

M110295

BE 09/08/10

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R ☐ ☐ Aluminum Rod

M110295

BE 09/08/10

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

①

A

9/8/10

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	=> S 09/08/10			(+0)	φ		
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> S 09/08/10			(+0)	φ		
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	=> H 09/08/17			(X1)	φ		

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:00pm OVEN TEMPERATURE: 320°F FINISH TIME: 12:30pm								
190 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

Handwritten: 08/08/17 (X) Ø

Handwritten: => 02/02/18

Handwritten: (X) Ø

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of
Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with
Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 112106

MD 09/08/20

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July 31, 2009 8:34:19 AM



Page 7

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Cust Item ID:

Required Date: 09/04/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

2) Sor/08/21



220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: PPPPPP Rev: 512606

Pc 9/2/01

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/02

Pl 09-9-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July.31, 2009 8:34:19 AM

Page 1/9

Work Order ID: 50842



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/13/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	7.0000	1.0000			
										1	08-8-7	
205 Skidtube bent detail												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

48616

1

50760

6

D2576-3RevG

Manufactured

No

140

Each

165.0000

1.0000



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

165

43504

62

46661

103

201 BE 09/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July 31, 2009 8:34:19 AM

Work Order ID: 50842

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Parent Item Name: Replacement Skidtube


Start Date: 08/13/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE 		Manufactured	No			140	Each	412.0000	20.0000			
Crossbolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	412	
43988	4	
46434	4	
46956	12	
47797	338	
48272	54	

20 BE 09/08/10

D2855RevA


Manufactured No

200 Each 66.0000 1.0000

Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6	52	
50513	52	

Main Warehouse

ST	14	
10360	2	
35663	7	
41340	1	
42343	3	
42806	2	
50513	-1	

XI MD 09/08/00

W/O:		WORK ORDER CHANGES					
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Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			200	Each	2,560.000	2.0000			

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2560	
100188	246	
105057	2246	
15205	68	

X2 mp 09/08/20

AN960JD10L

Purchased

No

200

Each

6,911.000 2.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6911	
101291	16	
104885	153	
105793	236	
109632	1506	
110985	5000	

X2 mp 09/08/20

July 31, 2009 8:34:19 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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ALS7-1032-130		Purchased	No			200	Each	3,706.000	50.0000			
												
Insert												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3706

105855

16

108606

52

111529

1638

111779

2000

250 MD 09/08/20

AN3C4A

Purchased

No

200

Each

2,071.000

50.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2071

112082

121

112314

1950

250 MD 09/08/20

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AN960C10L  washer		Purchased	No			200	Each	4,591.000	50.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4491

112116

4491

D3566-13RevC

Manufactured

No

200

Each

47.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

47

45717

1

46889

5

47435

7

48166

18

50265

16

X50 MD 09/08/20

X1 MP 09/08/20

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D3566-5RevC		Manufactured	No			200	Each	22.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

22

36113

1

46186

1

47318

1

48167

19

D3566-1RevC

Manufactured

No

200

Each

34.0000

2.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

34

46349

1

47434

2

48165

8

48557

11

50278

12

BS1260

x1 09/08/20

BS1259

x2 MD 09/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments:

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-11RevD

Manufactured

No

200

Each

30.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

30

45823

1

47432

7

48553

12

50112

10

X1 MD 09/08/20

D3564-13RevD

Manufactured

No

200

Each

55.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP17

35

48554

13

50270

22

Main Warehouse

ST

20

45409

3

46495

10

47867

7

X1 MD 09/08/20

W/O:		WORK ORDER CHANGES					
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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD  Wearshoe		Manufactured	No			200	Each	17.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

17

44659

1

45825

1

47316

4

48556

11

D3564-5RevD

Manufactured

No

200

Each

22.0000

1.0000

Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

12

48555

12

Main Warehouse

ST

8

45824

1

47433

1

48164

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 31, 2009 8:34:19 AM

Work Order ID: 50842



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube



Start Date: 08/13/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	894.0000	16.0000			
												
O-Ring, 205 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 894

27168 44

29908 850

D2594-1RevC

Manufactured No

200

Each

700.0000

16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 700

42221 16

42807 92

43884 87

46435 3

47251 502

X16 MD 09/08/20

X16 MD 09/08/20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

40-80-50
JUN
CH805#

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL B
SCALE 5:24

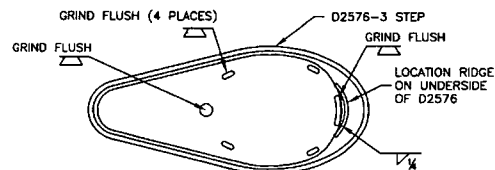


Diagram illustrating the assembly of a bolted joint. The components and dimensions are labeled as follows:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-5A BOLT (1)
- AN960/D10L WASHER (1)
- (2 PLACES)
- D2855 CAP
- 0.208
- 0.40

Diagram of a wheel assembly with labels:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)
- AFTER PERFORM
- 1. CHA
- 2. INS
- 3. WE
- 4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:



1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

[illegible][illegible]

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	
CHECKED	
DATE	07.02.27

DRAWN BY	PH
APPROVED	#

DART

DART AEROSPACE LTD.
HARRISVILLE, ONTARIO, CANADA

DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Diagram illustrating the underside of the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{8}$

Technical drawing of a circular component, likely a cap or cover, showing various fasteners and a seal. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two small circles on the left side of the component.
- #0.208**: Dimension for the diameter of the two small circles.
- AN3-SA BOLT (1)**: Points to a bolt on the left side.
- AN960JD10L WASHER (1)**: Points to a washer on the left side.
- D2855 CAP**: Points to the main circular component.
- SEAL WITH SIKAFLEX-241/-291**: Points to a rectangular seal on the right side.
- SEE NOTE ii)**: Points to a dashed line on the right side.
- 0.40**: Dimension for the width of the seal.

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION


Elevation view of the bridge deck showing reinforcement details. The diagram includes the following dimensions and annotations:

- Top Reinforcement:**
 - Distance to aft end of D2596 web: 37.50
 - Reinforcement bars labeled 3 and 7.
 - Bar spacing: 1.750
 - Bar diameter: #0.508 (TYP.) (40 PLACES)
- Bottom Reinforcement:**
 - Reference to Detail A at the left support.
 - Dimensions from the left support: 8.750, 17.375, 26.000, 34.188.
 - Dimension from the right support: 57.313 (REF).
 - Reinforcement specification: 7 EQUAL SPACES B.188 PITCH.
 - Total length dimension: 91.500.
 - End dimension: 190.0 (D2500-1).
- Other Annotations:**
 - Reference to Detail E at the right support.

Technical drawing of a curved pipe section. The drawing shows a horizontal pipe with a curved section. Key dimensions and callouts include:

- Overall length: 51.340
- Distance from left end to first hole: 5.985
- Distance between holes: 5.338 (REF)
- Distance from second hole to end of curve: 39.580
- Distance from end of curve to right end: 5.915
- Radius of curve: $\phi 0.508$ (8 PLACES)
- Distance from right end to tangent point: 32.0 ± 1.0
- Distance between hole and tangent point: 1.0
- Distance from left end to tangent point: 13.4
- Distance from left end to hole: 1.4
- Callout 4: Points to the left end and the curve.
- Callout 4: Points to the right end.
- Callout $\phi 0.640$: Points to the right end.

[illegible]

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DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

NO. 205

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: D205 634-041 50835
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier [Signature] Date of Test Coupon 09-07-30

Welder [Signature] Date of Test Coupon 09/07/30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld